

Date: Wednesday, 7/4/2007 3:57:53 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : GPS RECEIVER HOUSING

Job Number : 33305

Estimate Number : 12494

P.O. Number : N/A

Part Number : D35147

This Issue : 7/4/2007

S.O. No. : N/A

Drawing Number : UNDER REVIEW

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A

Type : SMALL / MED FAB

Drawing Revision : N/A

Previous Run : 32537

Material : N/A

Due Date : 7/11/2007

Qty: 1 Um: Each

PROTOTYPEWritten By : *[Signature]*Checked & Approved By : *[Signature]*

Comment : Est Rev:A New Issue 06-07-26 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S040

6061-T6 .040 Sheet



Comment: Qty.: 0.2518 sf(s)/Unit Total : 0.2518 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *M 103321 100742*CERTIFICATE OF CONFORMITY
REQUIRED

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *PROL*Prog Rev: *PROL*

Ensure Grain Direction is correct**

2-Deburr if necessary *H**MF 07-07-09**(Pto)*

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-07-10

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/07/10 (X1)

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE


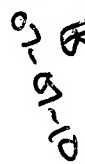

Form Joggle as per Dwg D3514

*SP 02/07/10**07/10/10*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-7 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>33305</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.07.09	2.0	1 Part SCRAP wrong mat. used 0.050" instead of 0.040" R.C. Human Error	 05/10/12	Scrap and replace mat with correct mat. Remind Employee to be more cautious when pulling mat. BATCH # M 102723 M100742	03-01-10 	En 07/07/10	 05/10/12	En 07/07/10

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

FAI NEEDS MORE
DIMS

INSPECT WORK TO CURRENT STEP



CB 07.07.11

**ENGINEERING
APPROVAL**



07.07.16

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per Q91 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

FOR ENGINEERING USE ONLY

07.07.19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

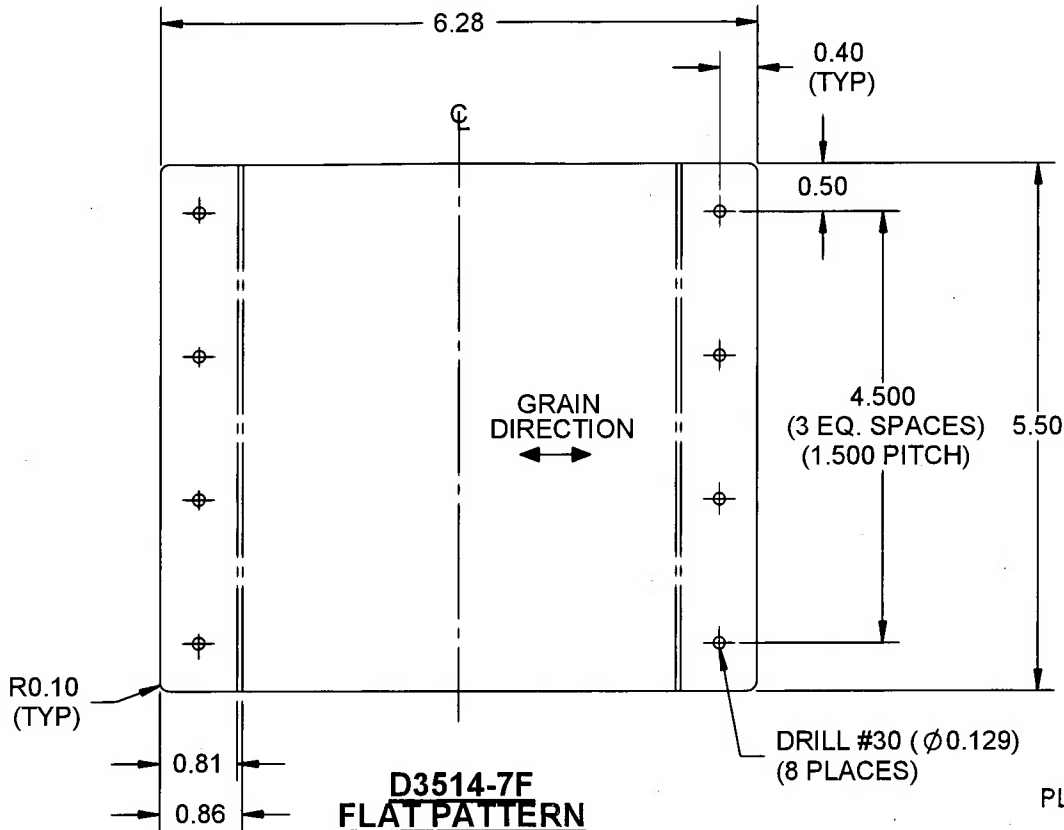
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



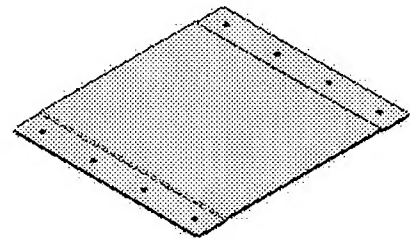
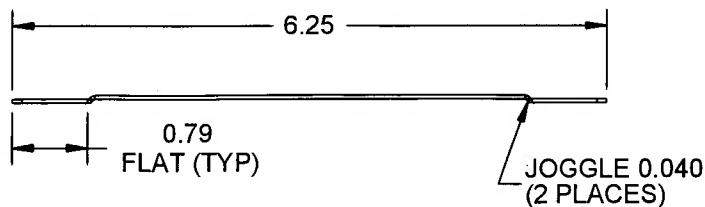
07/07/18

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3514	REV. A SHEET 8 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:2



Handwritten signature/initials

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22



NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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Receiving Report

Date: April 21/06
 Supplier: Copper & Brass

Batch No: 51100742
 Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐
 Shipment Complete: Yes ☐ No ☒
 Q.C. Inspection ☐

Discrepancies		Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
Part No	Description					
M50524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0050		12	10	0	2	

ISR No: _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin: _____
 Date: 06/04/25
 Received/Costing: PCP1298
 Initial: [Signature]

Accounting: _____
 Date: _____
 AP/MR: _____
 Initial: _____

FORM 09000 (Form 1) Purchase RECEIPT rev B


DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
GST/HST				9.66
PLEASE REMIT IN CANADIAN FUNDS				
TOTAL \$				147.73

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

10294	SHIP DATE 04/24/06 SHP	GROSS WEIGHT	QUOTE 30-161074-1	0 OF 10 PACKING LIST		
ART AEROSPACE		WORK ORDER **	ORDER DATE 04/13/06 ORD	TEST RESULTS		
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA K6A 1K7		DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30 (04)	SELL BRANCH 30-TOR	WORK ORDER UZ3809	
6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		Copper and Brass Sales Canada  A ThyssenKrupp Materials NA company ThyssenKrupp				
ORDER PO NUMBER 000001005	TERRITORY 01	ENTRY ID 30BXT	CUSTOMER SIGNATURE: _____ DATE: _____			
INSIDE SALES LINDA LACELLE	INSIDE SALES TELEPHONE (905) 696-8100 37622		QUANTITY	ORDERED	SHIPPED	
INVENTORY			54.19 LB	52.00		
BILLING			2.00 PC	2.00		
SHIP VIA			SHIPPING STATUS			
COMPLETE X			PARTIAL			
CUSTOMER COMMON/FRT-CCX			WAREHOUSE			
FREIGHT STATUS PPD			PACKED WITH OTHER GOODS UZ3800			
FINISHED GOODS LOCATION			WARN LABEL: 1001			
PART DESCRIPTION			063496-4			

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 ART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions., Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

Rec'd 4/21

SPECIAL INSTRUCTIONS									
Shipping, do not place any packages or goods on top of our material."									
SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT			
MAX SKID WEIGHT 100		LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK				MAXIMUM BUNDLE WEIGHT 200			
BAKS	CASES	CUSHP	PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT	COILS
INSPECTION RECORD									

TEST RESULTS -----

WE HEREBY CERTIFY THAT MERCURY OR ANY OF ITS COMPOUNDS ARE NOT USED IN THE PROCESSING AND DISTRIBUTION OF OUR PRODUCTS.
 OUR PRODUCTS WE DISTRIBUTE ARE NOT HAZARDOUS IN THEIR RECEIVED STATE. FOR MSDS SHEETS GO TO www.copperandbrass.com/msds
 1-800-249-2333-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027	ASTM-B209	ROHS COMPLIANT	QUANTITY UOM VENDOR VENDOR PO HEAT/LOT	PCS ! TAG NO	QUANTITY UOM VENDOR VENDOR PO HEAT/LOT	PCS
52.00 LB CORUS	0CC1837 7124901					